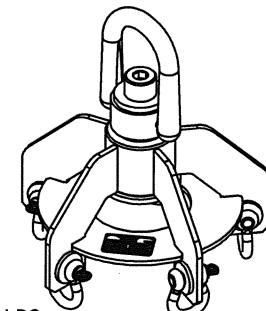
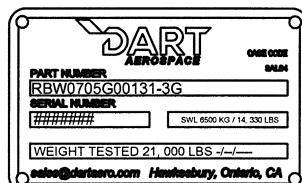
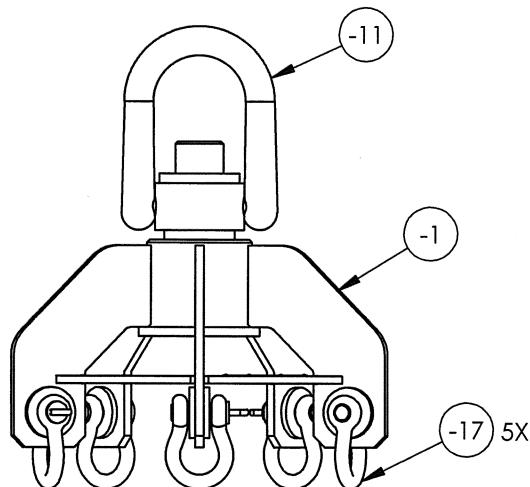
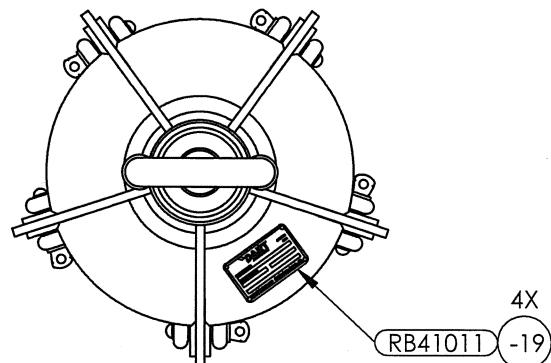


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NOTES:

1. WEIGHT TEST TO 21,000 LBS.
2. RBW0705G00131-3G REPLACES AGUSTA T/N 3G0705G00131.
3. TORQUE HOIST RING TO RECOMMENDED TORQUE SHOWN ON THE RING.



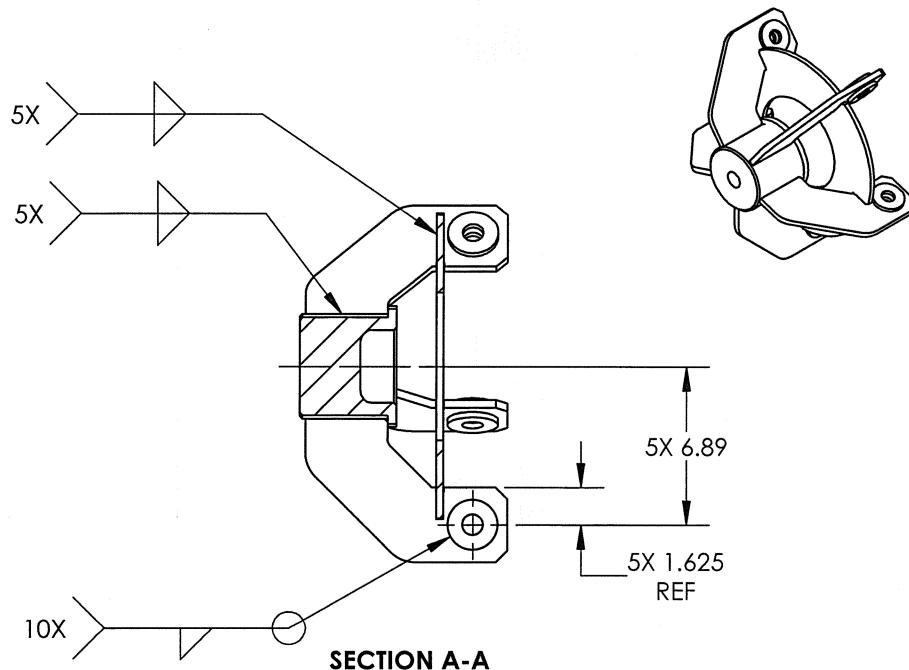
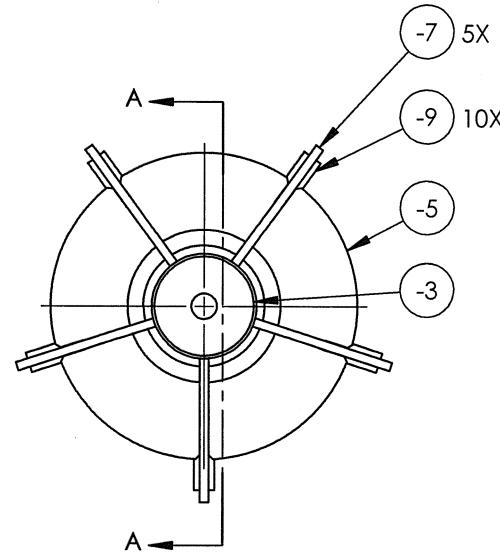
TITLE AC & MR LIFTING SLING

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	DWG NO.	REV
X	-1	1	WELDMENT					2	RBW0705G00131-3G	K
1	-3	1	CENTER PIN		4140			3	MAT'L	
1	-5	1	RING		4140			4	HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125
5	-7	1	ARM		4140			5	FINISH	
10	-9	1	SPACER		4140			6	SPEC	
B/O	-11	1	HOIST RING		FORGED ALLOY STEEL	15,000 lbs. MCMASTER-CARR #2994T81		1	DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
B/O	-15	1	DART PLACARD		ALUMINUM	RB41011		1	CHECKED: SM 02/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
B/O	-17	5	ANCHOR SHACKLE W/SCREW PIN		GALV. STEEL	Ø3/4 PIN 3-1/2 TON (MCMASTER-CARR #3558T51)		1	OPPS APPR: AA 02/13/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
B/O	-19	4	#2 DRIVE SCREW		COATED STEEL	#2 X 1/4 (MCMASTER-CARR #90081A077)		1	QA APPR: JL 05/09/2017	USED ON MODEL
ASSY -1									APPROVED: <i>JL</i>	AW139
								SCALE N/A	DATE 4/1/2009	SHEET 1 OF 7

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REVISONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 & -5 SEPARATED WELDING & ASSEMBLY DWGS.	10/29/2010	WP	DW
3		-1 DELETED ENGRAVE NOTE.	8/29/2011	RJC	RW
6	17-0039	-1 CH'D WELD NOTE WAS 5X FILLET NEAR SIDE, FAR SIDE, ALL AROUND IS 5X FILLET NEAR SIDE, FAR SIDE. CH'D FINISH WAS POWDER COAT RED WAGON FORREST #T-3370 S9 IS POWDER COAT RED.	2/9/2017	DPD	JAG
K		FINISH WAS POWDER COAT RED IS POWDERCOAT RED QSI 005 OR MIL-PRF-24712	2/13/2019	VM	VM



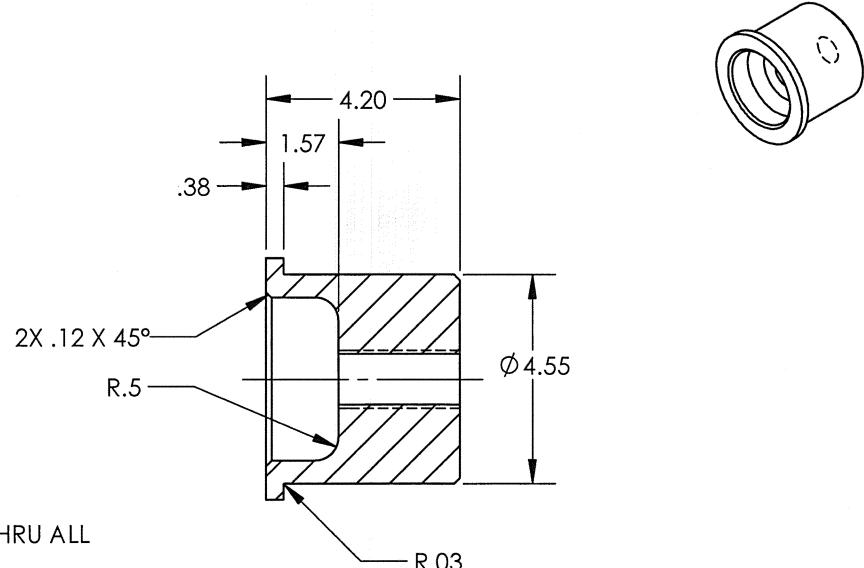
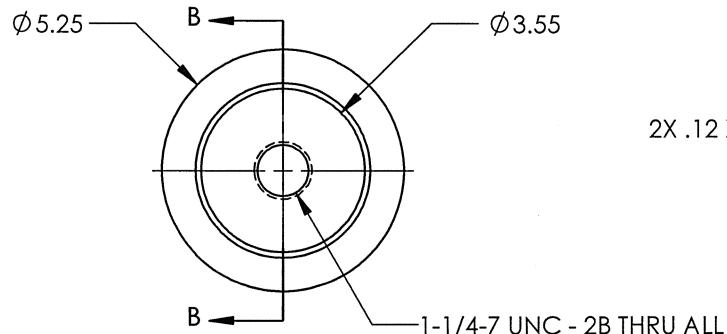
(-1)

WELDMENT

DART AEROSPACE	
TITLE	
AC & MR LIFTING SLING	
DWG NO. RBW0705G00131-3G-1 REV K	
MAT'L UNLESS OTHERWISE SPECIFIED	
HEAT DIMENSIONS ARE IN INCHES	
TREAT .XXX ± .005 FRACTIONS ± 1/8	
FINISH POWDERCOAT RED QSI 005 OR MIL-PRF-24712	
SPEC X .XX ± .01 ANGLES ± 1°	
DRAWN BY: PERRITT SURFACES = 125 ✓	
CHECKED: SM 02/10/2017	
OPPS APPR: AA 02/13/2017	
QA APPR: JL 05/09/2017 USED ON MODEL	
APPROVED: AW139	
SCALE	N/A
DATE	4/1/2009
SHEET 2 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 REDESIGNED TOOL CENTER PIN WAS Ø5.50 X 10.06 WITH A SHACKLE HOLE NOW ITS Ø5.25 X 4.20 WITH AN EYEBOLT HOLE, ADDED EYE BOLT AND DWG.	10/29/2010	WP	DW
2		-3 CH'D DEPTH OF BORE FROM 2.95 TO 1.57 & THREADED HOLE 1-1/4-7 UNC.	12/8/2010	RJC	
3		-3 ADDED .12 X 45° CHAMFER.	8/29/2011	RJC	RW
5	15-0301	-3 CH'D MATERIAL CALLOUT WAS 1018 IS 1018/1020.	9/15/2015	RJC	JAG
6	17-0039	-3 CH'D MAT'L WAS 1018/1020 IS A514 CR.	2/10/2017	DPD	JAG
K		MATERIAL WAS A514 CR IS 4140 Rc 28-32	2/13/2019	VM	VM



SECTION B-B

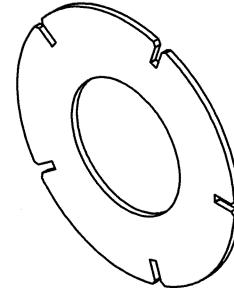
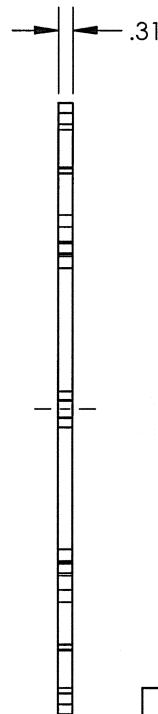
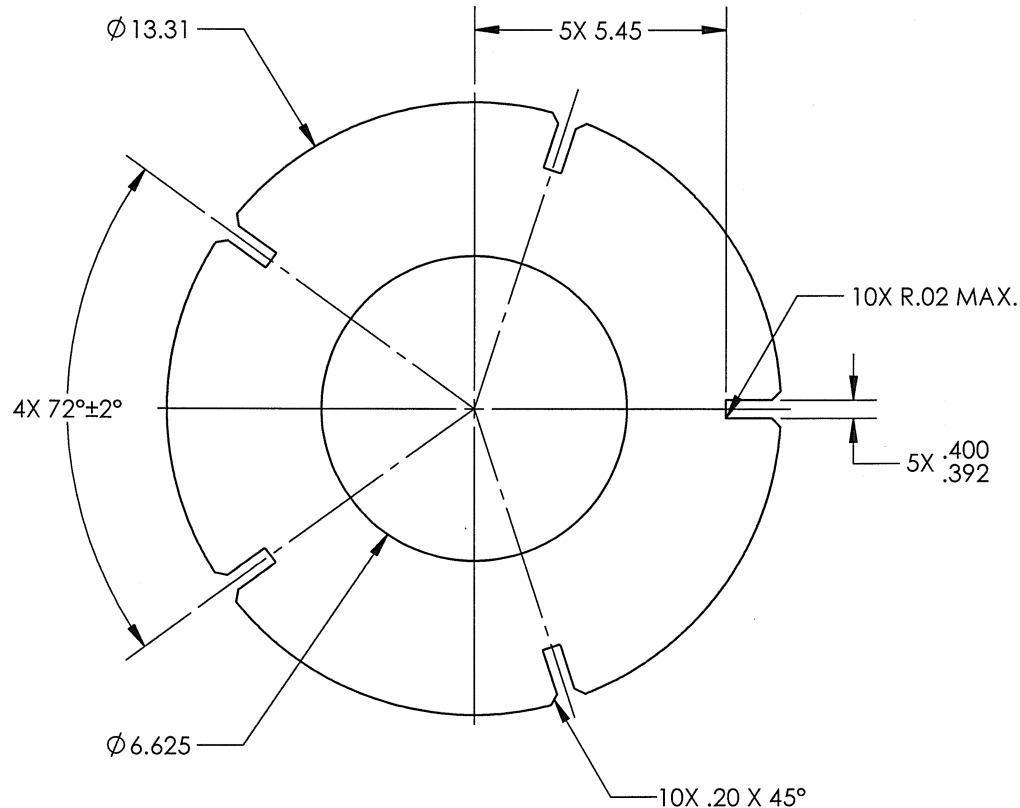
(-3)

CENTER PIN

DART AEROSPACE	
TITLE	
AC & MR LIFTING SLING	
DWG NO. RBW0705G00131-3G-3 REV K	
MAT'L 4140 HEAT TREAT 28-32 Rc FINISH SEE -1 SPEC	
DRAWN BY: PERRITT CHECKED: SM 02/10/2017 OPPS APPR: AA 02/13/2017 QA APPR: JL 05/09/2017 APPROVED: WJL AW139	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE	N/A
DATE	4/1/2009
SHEET 3 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 CH'D ENGRAVE NOTE.	5/27/2009	RJC	
5	15-0301	-5 CH'D MATERIAL CALLOUT WAS 1018 IS 1018/1020, ADDED .20 X 45° CHAMFER AND 10X R.02.	9/15/2015	RJC	JAG
6	17-0039	-5 CH'D MAT'L WAS 1018/1020 IS A514 CR. CH'D DIM WAS 5X .375-.385 IS 5X .392-.400.	2/10/2017	DPD	JAG
K		MATERIAL WAS A514 CR IS 4140 Rc 28-32	2/13/2019	VM	VM



(-5)

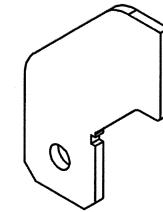
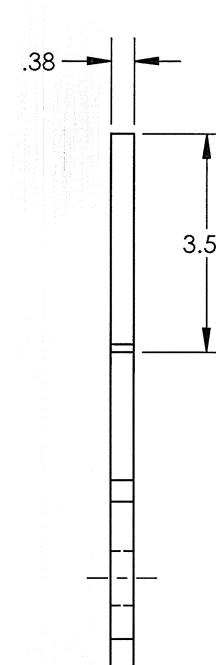
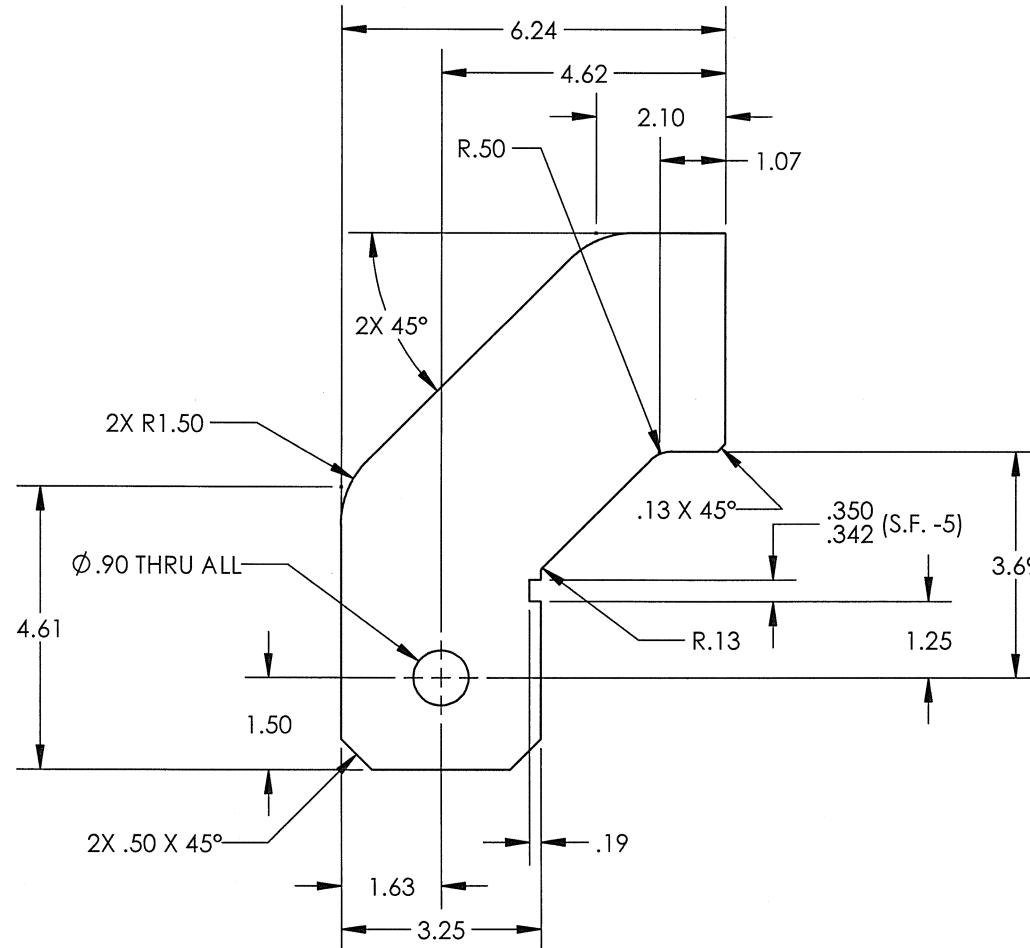
RING

TITLE		DWG NO.		REV
AC & MR LIFTING SLING		RBW0705G00131-3G-5		K
MATERIAL 4140		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
HEAT TREAT 28-32 Rc		.XXX ± .005 FRACTIONS ± 1/8		
FINISH SEE -1		.XX ± .01 ANGLES ± 1°		
SPEC		.X ± .1 SURFACES = 125		✓
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R		
CHECKED:	SM 02/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
OPPS APPR:	AA 02/13/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
QA APPR:	JL 05/09/2017	USED ON MODEL		
APPROVED:	WT	AW139		
SCALE	N/A	DATE	4/1/2009	SHEET 4 OF 7

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 ARM WAS .38 X 6.14 X 9.88 IS .38 X 6.24 X 8.75.	10/29/2010	WP	DW
4		-7 CH'D DIM WAS .323 - .313 IS (.313) S.F. -5.	6/17/2014	DJN	GE
5	15-0301	-7 CH'D MATERIAL CALLOUT WAS 1018 IS 1018/1020, ADDED .12 X 45° CHAMFER.	9/15/2015	RJC	GE
6	17-0039	-7 CH'D MATL WAS 1018/1020 IS A514 CR. CH'D DIM WAS (.313 S.F. -5) IS .350-.342 (S.F. -5).	2/10/2017	DPD	JAG
K		MATERIAL WAS A514 CR IS 4140 Rc 28-32	2/13/2019	VM	VM



(-7)

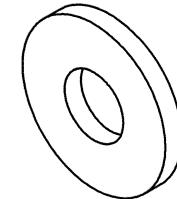
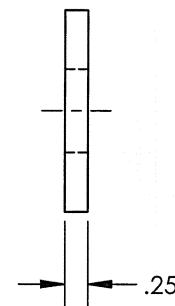
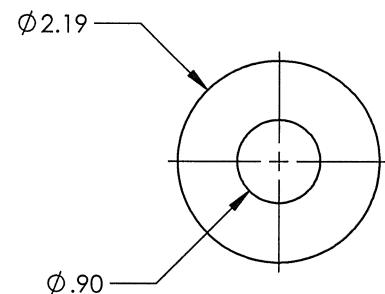
ARM

TITLE		DART AEROSPACE	
DWG NO.		AC & MR LIFTING SLING	
		RBW0705G00131-3G-7	
DRAWN BY:		PERRITT	
CHECKED:		SM 02/10/2017	
OPPS APPR:		AA 02/13/2017	
QA APPR:		JL 05/09/2017	
APPROVED:		VTP AW139	
SCALE	N/A	DATE	4/1/2009
SHEET 5 OF 7			

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 1°
X ± .1 SURFACES = 125°
1. BREAK ALL SHARP EDGES ✓
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL

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REVISIONS								
REV	ECR	DESCRIPTION				DATE	INITIAL	APPROVED
6	17-0039	-9 CH'D MAT'L WAS 1018/1020 IS A514 CR.				2/10/2017	DPD	JAG
K		MATERIAL WAS A514 CR IS 4140 Rc 28-32				2/13/2019	VM	VM

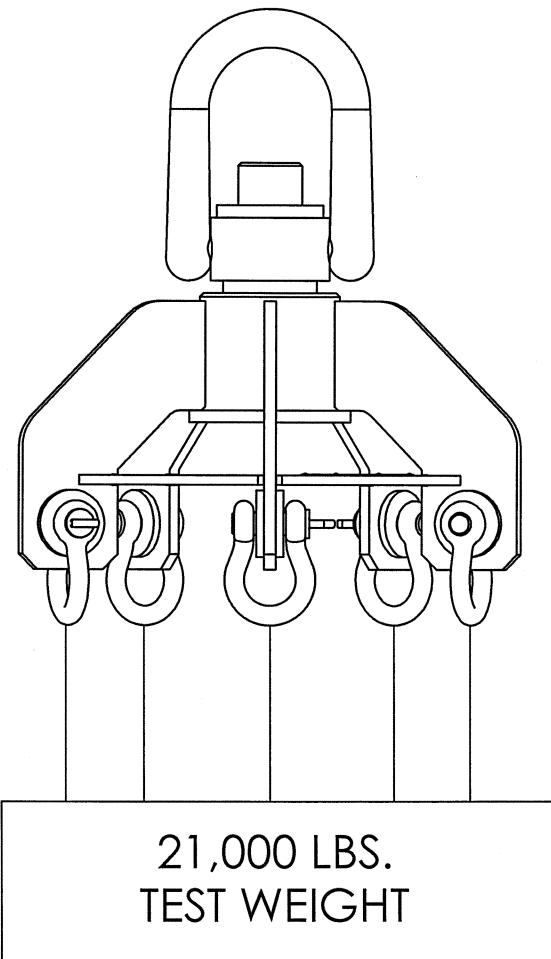


(-9)
SPACER

DART AEROSPACE	
TITLE	
AC & MR LIFTING SLING	
DWG NO.	RBW0705G00131-3G-9
REV	K
MAT'L 4140 UNLESS OTHERWISE SPECIFIED	
HEAT TREAT 28-32 Rc DIMENSIONS ARE IN INCHES	
FINISH SEE -1 XXX ± .005 FRACTIONS ± 1/8	
SPEC XX ± .01 ANGLES ± 1°	
DRAWN BY: PERRITT X ± .1 SURFACES = 125 /	
CHECKED: SM 02/10/2017 1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 02/13/2017 .015 x 45° OR .015R	
QA APPR: JL 05/09/2017 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: VMP 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE	N/A USED ON MODEL
DATE	4/1/2009
SHEET 6 OF 7	

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REVISIONS						
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
3B			ADDED FIRST ARTICLEWEIGHT TEST SHEET.	10/31/2013	RJC	RW
6	17-0039		1ST PARAGRAPH ADDED LIFTING THE AIRCRAFT.	2/9/2017	DPD	JAG



INSPECTION & TESTING PROCEDURES FOR THE RBW0705G00131-3G, AC & MR HEAD LIFTING SLING. THIS ASSEMBLY IS DESIGNED EXCLUSIVELY FOR LIFTING THE AIRCRAFT AND INSTALLING/REMOVING THE MAIN ROTOR HEAD.

INSPECT THIS ASSEMBLY PRIOR TO EACH USE. **REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING.**

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION PLACE SLING ASSEMBLY ON A OVERHEAD LIFTING DEVICE. ATTACH 5 CONNECTOR HOOKS TO AN APPROPRIATE TEST WEIGHT OF 21,000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTION.

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

	
190 S. Danebo Ave., Eugene, OR. 97402	
1-800-556-4166	
e-mail: sales@dartaero.com	
dartaerospace.com	
TITLE	
AC & MR LIFTING SLING	
DWG NO.	REV
RBW0705G00131-3G	K
SCALE	DATE
N/A	2/13/19
CUSTOMER 1 OF 1	
SHEET 7 OF 7	